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~~for manufacturing a lightweight valve.~~ The method ~~proposes that~~ according to the present invention provides for a first one-piece component forming the valve disk and the gripping receiver is produced by casting, forming and/or by means of a powder metallurgy method in a first step. A second one-piece component forming the valve stem is produced in a second step. In this connection, the valve stem can be of hollow design or consist of solid material. In a third step, a third component forming the valve cone is produced, preferably by means of a forming operation. In a fourth step, the first and second components are then fitted together. In the process, the valve stem engages in the valve disk gripping receiver, by virtue of which the components are centered in relation to one another and at the same time interconnected securely. Valve disk and valve stem are subsequently interconnected inseparably by means of a material connection. Finally, the hollow valve cone is pushed onto the valve stem and brought to lie with its end of greater diameter opposite the valve disk. The through-opening in the valve cone preferably has a guiding and centering portion, so that accurate alignment of the valve cone relative to the valve stem and the valve disk takes place when the valve stem is pushed through. Finally, the valve cone is connected inseparably to both the valve stem and the valve disk by means of a material connection. Owing to the design according to the invention of the lightweight valve, relative alignment/centering of the individual components is possible in a simple way without special aligning devices being essential for this.

Please delete paragraph [0014].

Please add the following new heading before paragraph [0015]:

BRIEF DESCRIPTION OF THE DRAWINGS

after KW 2/4/11

Please add the following new heading ~~before~~ paragraph [0018]:

DETAILED DESCRIPTION

Please amend the heading on top of page 11 with the following amended heading:

~~Patent claims~~ WHAT IS CLAIMED IS: